

Work Order ID 62182

Monday, September 20, 2010 12:47:33 PM



Page 1

Item ID: PB67-43001-261

Accept



Setup Start



Revision ID:

Item Name: Lever Arm

Stop



Start Date: 9/21/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/11/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-9-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg B67-43001								
<i>6061 .250</i>	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00							
QC									
Quality Control									

*mf not pulled**10-9-28**10-9-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

BL 10-9-30

140



Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

Powdercoat

Memo

0.00

0.00

0.00

BL 10-10-6

START TIME: 2:05

OVEN TEMPERATURE: 320°

FINISH TIME: 2:35

(12)

(12) - S.

12 - S.

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Required Date: 10/11/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC3- Inspect Part Finish

0.00

10/10/12 SP 100

QC

Quality Control

160



Identify as per dwg & Stock Location: 422

0.00

10/10/12 SP 100

Packaging

Packaging

Memo

0.00

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/10/12 AF

UNF
10-10-12

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 1

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Work Order ID: 62182



Parent Item: PB67-43001-261



Parent Item Name: Lever Arm

Start Date: 9/21/2010

Required Date: 10/11/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A□05.06.07□New issue□KJ/JLM□

IPP Rev:B 08-06-23 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X06.00 0		Purchased		No		100	f	36.0000	1.388	17.53263	16.656		

6061-T6 Bar .250 x 6.00



16.656

Location	Loc Qty	Loc Code
MAT	12	
115212	12	
MAT01	24	
115165	24	

$115212 \times 8 = 11.104$

$115165 \times 4 = 12 \times 5.552$

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DART AEROSPACE LTD	Work Order:	b2182
Description: Lever Arm	Part Number:	B67-43001-261
Inspection Dwg: B67-43001 Pg39 Rev: B/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-9-78	Date:	10/09/88	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.07.25	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

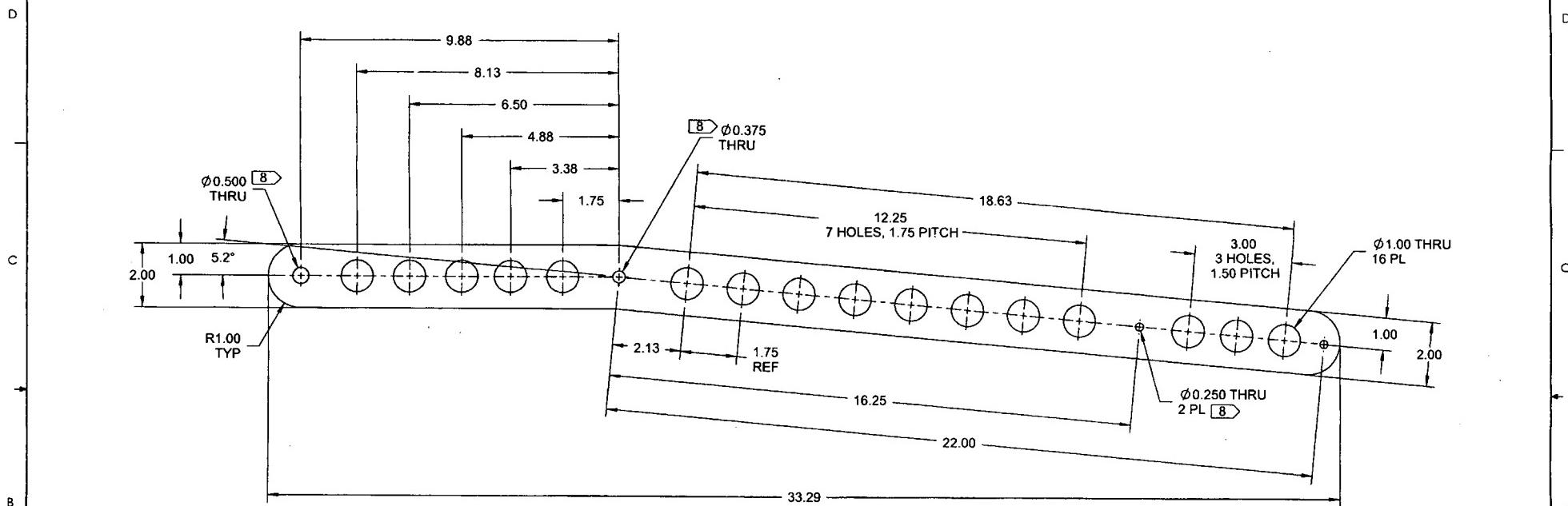
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

B67-43001-261 LEVER ARM

62182
RELEASED
2009-09-24
MD

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.250 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 REF. DART SPEC. M6061T6S.250
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs
- 8) MASK PRIOR TO POWDER COAT

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 39 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.			MB	09.03.11
REV.	DESCRIPTION	BY	DATE		
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		DRAWING NO.	B67-43001-261	REV. C	SHEET 1 OF 1
CHECKED		MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	DE APPR.	N/A	LEVER ARM	NTS
DATE	09.03.11				

8 7 6 5 4 3 2 1

A

D

C

B

A

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